

Application Serial No.: 10/659,246  
Amdt. dated December 14, 2005  
Reply to Office Action of June 14, 2005

**LISTING OF CLAIMS**

This listing of claims will replace all prior versions, and listings, of claims in the application:

Claims 1-39 (Cancelled)

40. (Previously Presented) A method for manufacturing a storage device for plate-shaped data carriers, said storage device having a first and a second cover pivotally connected, and having an authentication means, comprising:

positioning an authentication means in a mold for injection molding one of said first and second covers such that said authentication means provides a surface against which injected plastic is molded; and

injection molding plastic against or around said authentication means in said mold, such that said authentication means cannot be removed from said first or second cover without damaging said authentication means and/or said first or second cover.

41. (Previously Presented) A method according to claim 40, wherein said storage device is injection molded in one piece.

42. (Previously Presented) A method according to claim 40, wherein said authentication means further comprises:

providing a printing;

placing said printing in said mold; and

injecting plastic into said mold to contact said printing such that said printing will form an integral part of said first or second cover formed in said mold.

43. (Previously Presented) A method according to claim 42, wherein said printing is introduced into said mold on a carrier.

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44. (Previously Presented) A method according to claim 43, wherein said mold further comprises placing said carrier adjacent a wall of said mold and said plastic is injected to contact said carrier and said mold wall.

45. (Previously Presented) A method according to claim 43, further comprising stretching said carrier before or during placement in said mold, such that said carrier is pulled taut.

46. (Previously Presented) A method according to claim 43, wherein said carrier burns or sublimes, while the printing is incorporated on or into the plastic when said plastic is injected into said mold.

47 (Previously Presented) A method according to claim 43, wherein said carrier fuses with said plastic.

48. (Previously Presented) A method according to claim 43, further comprising supplying said carrier in a roll, and cutting a portion for placement in said mold before placing said portion in said mold.

49. (Previously Presented) A method according to claim 42, wherein said printing is designed as a transfer.

50. (Previously Presented) A method according to claim 42, wherein said printing is provided in said mold through impressing or printing on a wall of said mold or a carrier provided thereon.

51. (Previously Presented) A method according to claim 42, wherein said printing further comprises providing a holographic printing.

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52. (Previously Presented) A method according to claim 42, wherein said printing further comprises providing a bar-code.

53. (Previously Presented) A method according to claim 43, wherein said carrier is provided in said mold, having a printing on two sides, said plastic being provided against said carrier and undetachably connected thereto.

54. (Previously Presented) A method according to claim 53, wherein said carrier is at least partially transparent.

55. (Previously Presented) A method according to claim 40, wherein said authentication means is a magnetic and/or electronic means which is positioned on a carrier in the mold, and injecting plastic around the magnetic and/or electronic means, such that said carrier is enclosed or incorporated therein or disappears therein through burning or sublimation.

56. (Previously Presented) A method according to claim 40, further comprising providing a mold cavity in said mold for forming a fixing means within said storage device for fixing said plate shaped data carrier in said storage device.

57. (Previously Presented) A method according to claim 56, wherein said mold cavity for forming said fixing means in said first or second cover part is provided for holding a CD.

58. (Previously Presented) A method according to claim 56, wherein said mold cavity further comprises providing a surface for forming resilient fingers in said storage device for holding said data carrier in place.

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59. (Previously Presented) A method according to claim 43, further comprising:  
providing said carrier in a roll for feeding into said mold;  
providing a frame for positioning a portion of said carrier containing said authentication means in said mold;  
positioning said portion of said carrier on said frame;  
positioning said frame holding said portion of said carrier in said mold against a sidewall of said mold; and  
removing said frame from said mold prior to injecting said plastic.

60. (Previously Presented) A method according to claim 59, wherein further comprising cutting said portion of said carrier containing said authentication means from said roll prior to positioning said portion of said carrier onto said frame.

61. (Previously Presented) A method according to claim 60, wherein said mold further comprises forming the first and second covers in one piece with an integrated hinge to allow for a one piece storage device.

62. (Previously Presented) A method according to claim 61, further comprising providing a hinge cavity in said mold for forming an integrated one piece hinge between said first and second covers.

63. (Previously Presented) A method according to claim 60, wherein said plastic further comprises providing said plastic for injection molding with a melt of at least 30.

64. (Previously Presented) A method according to claim 60, wherein said plastic further comprises providing said plastic for injection molding with a melt of at least 50.

65. (Previously Presented) A method according to claim 40, wherein said injection molding plastic further comprises forming a transparent first or second cover for viewing said authentication means.

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66. (Previously Presented) A method according to claim 65, wherein said authentication means further comprises providing a two-sided printing that is viewable from an inside surface and an outside surface of said first or second cover part.

67. (Previously Presented) A method according to claim 40, further comprising providing a product specific printing related to said data carrier as said authentication means.

68. (Previously Presented) A method according to claim 40, further comprising providing an electronically readable form related to said data carrier as said authentication means.

69. (Previously Presented) A method for manufacturing a product comprising a plate-shaped data carrier in a storage device, said storage device having a first and a second cover pivotally connected, and having an authentication means, comprising:  
positioning an authentication means having product specific printing corresponding to data on said plate-shaped data carrier in a mold for injection molding one of said first and second covers such that said authentication means provides a surface against which injected plastic is molded;  
injection molding plastic against or around said authentication means in said mold, such that said authentication means cannot be removed from said first or second cover without damaging said authentication means and/or said first or second cover; and  
loading said plate-shaped data carrier in said storage device.

70. (Previously Presented) A method according to claim 69, further comprising providing an electronically readable form related to said data on said data carrier as said authentication means.

71. (Previously Presented) A method according to claim 69, wherein said printing is introduced into said mold on a carrier.

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72. (Previously Presented) A method according to claim 71, wherein said printing further comprises providing a holographic printing.

73. (Previously Presented) A method according to claim 71, wherein said printing further comprises providing a bar-code.

74. (Previously Presented) A method according to claim 69, further comprising providing a mold cavity in said mold for forming a fixing means within said storage device for fixing said plate shaped data carrier in said storage device.

75. (Previously Presented) A method according to claim 74, wherein said mold cavity for forming said fixing means in said first or second cover part is provided for holding a CD.

76. (Previously Presented) A method according to claim 75, wherein said mold cavity further comprises providing a surface for forming resilient fingers in said storage device for holding said data carrier in place.

77. (Previously Presented) A method according to claim 69, further comprising providing a hinge cavity in said mold for forming an integrated one piece hinge between said first and second covers.

78. (Previously Presented) A method for ensuring authentic offers for sale of data carriers comprising:

forming a storage device having a first and second cover which are pivotally connected after molding comprising;

positioning an authentication means containing product specific information in a mold for either said first cover or said second cover such that said authentication means provides a surface against which injection molded plastic is molded;

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injection molding plastic against or around said authentication means in said mold such that said authentication means can not be removed from said first cover or said second cover without damaging said authentication means and or said first cover or said second cover; and

housing a data carrier with data contained therein in said storage device which authenticates its contents.

79. (Previously Presented) A method according to claim 78 further comprising offering said data carrier housed in said storage device to consumers for sale.

80. (Previously Presented) A method according to claim 79, wherein said authentication means is a product specific printing.

81. (Previously Presented) A method according to claim 80, wherein said product specific printing is introduced into said mold on a carrier.

82. (Previously Presented) A method according to claim 81, wherein said mold further comprises placing said carrier adjacent a wall of said mold and said plastic is injected to contact said carrier and said mold wall.

83. (Previously Presented) A method according to claim 82, further comprising stretching said carrier before or during placement in said mold, such that said carrier is pulled taut.

84. (Previously Presented) A method according to claim 83, wherein said carrier fuses with said plastic.

85. (Previously Presented) A method according to claim 79, wherein said authentication means is an electronically readable form.

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86. (Previously Presented) A method according to claim 79, wherein said authentication means is a holographic printing.

87. (Previously Presented) A method according to claim 79, wherein said authentication means is a bar-code.

88. (New) A method for manufacturing a storage device for a plate-shaped data carrier, the storage device having a first and second cover pivotally connected, and having an authentication element, the method comprising the steps of:

positioning a printer head adjacent a surface of an injection mold;

providing a transfer ink directly on said mold surface with said printer head, said transfer ink comprising a product specific printing; and

injection molding plastic against said mold surface, wherein said ink printing is transferred from said mold surface onto said plastic and is incorporated therein to form said authentication element.